

Date: Thursday, 8/23/2007 11:52:24 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 34234
 Estimate Number : 10673
 P.O. Number : N/A Part Number : D2975
 This Issue : 8/23/2007 S.O. No. : N/A Drawing Number : D2975 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A
 Previous Run : 29538 Material : N/A
 Written By : Due Date : 9/3/2007 Qty: 19 Um: Each
 Checked & Approved By : 07.08.23
 Comment : Est: C 02.10.23 Re-format KJ
 Est Rev:D Now on Waterjet 06-11-21 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.2896 sf(s)/Unit Total : 2.8959 sf(s)

1010/1025/A21/6aA SHEET .063"

Batch: M103434 1807-08-24

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2975

Dwg Rev: A

Prog Rev: A

1807-08-24

(A)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



18 07-08-24

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 09/08/27

counter
(X19)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form as per dwg D2975 using DT8261 & DT8326

SB 07/08/28
 SB 07/08/28

(19)
(19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: R Date: 07/09/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:24 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 34234

Part Number: D2975

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 9/08/28 (19)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8210 as per Dwg D2975 & QSI 004

Qty Description Batch

A/R 7560 Hardcoat Rod MID5465

SG 07/09/13

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/13 (19)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M/07/14

(19)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MS/Free.

07-09-14 (19)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/9/14

SP (19)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

19/09/17

Job Completion



CY 07/09/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

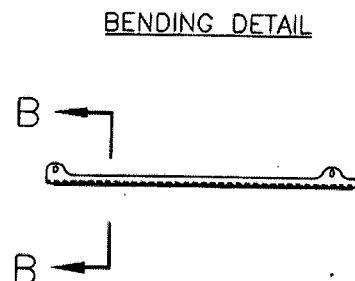
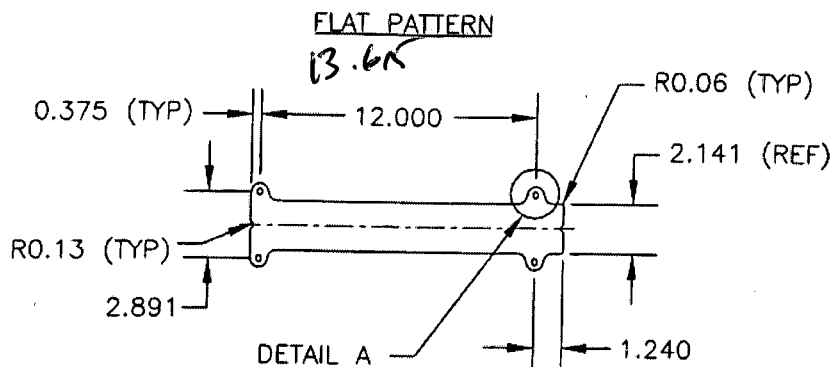
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

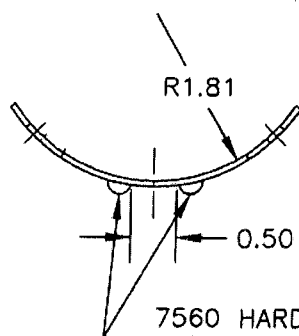
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2975	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE WEARPLATE	SCALE 1:8
A	00.03.10	NEW ISSUE	

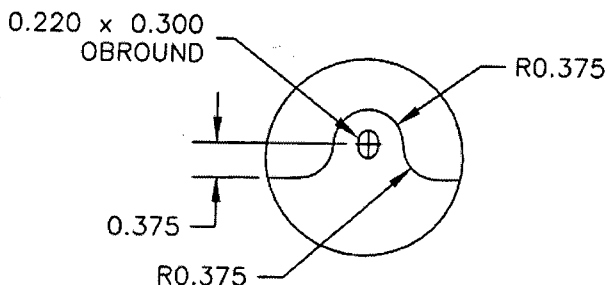


SECTION B-B
SCALE 2:5



7560 HARDCOAT WELDS TO
WITHIN 0.25 OF WEARSHOE
ENDS 0.063 TO 0.125 THICK

DETAIL A
SCALE 2:5



RELEASED
00.05.11 *[Signature]*

BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
16 GAUGE (0.063 THICK)

FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34234

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